

REVISION HISTORY					
REV	DATE	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED
A	5/28/19	INITIAL RELEASE	ZA	LS	ZA
B	7/24/19	-1 ASSY: ITEM 4 WAS -21 NOW -2, CHANGED BOTTOM SCREW CUT DIMENSION; -12 PART: REMOVED UNNECESSARY DISK, UPDATED BEND ID AND BEND CHART	ZA	LS	ZA
C	10/10/19	-12 PART: ADDED INSIDE RADIUS, SWAPPED BEND PUNCH & DIE NUMBERS; -13 PART: ADDED MANUFACTURING BEND TABLE; -14 PART: MOVED SECTION D3 HOLE TO PROVIDE CLEARANCE WITH TUBING; -16 PART: ADDED MANUFACTURING BEND TABLE, SECTION D3: HOLE TO PROVIDE CLEARANCE WITH TUBING, REDUCED FLANGE WIDTH TO FIX INTERFERENCE WITH -14, SECTION C3: INCREASED RELIEF CUT	ZA	LS	ZA
D	10/18/19	-1 ASSY: CHANGED ITEM 14 QTY TO 1, ADDED DOW CORNING RTV-732 BLACK AS POSSIBLE SEALANT; -1 ASSY: ITEM 14 QTY NOW 3, DETAIL G: HOLE LOCATION DIMENSION WAS .750 NOW .4; -7: CORRECTED RIVET P/N; -11: ADDED BEND TABLE; -14: ADDED BEND TABLE, ADDED MASKING LOCATION;	ZA	LS	ZA
E	10/13/21		ZA	DT	ZA

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PROTO

Paravion® Inc. Technology		TITLE RH FWD EVAPORATOR PARTS		DRAWING NUMBER 505AC-4403	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°					
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO
ZA			7/30/18		E
DO NOT SCALE DRAWING			SHEET		
 3RD ANGLE PROJECTION			© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		
1 OF 15					

PARTS LIST

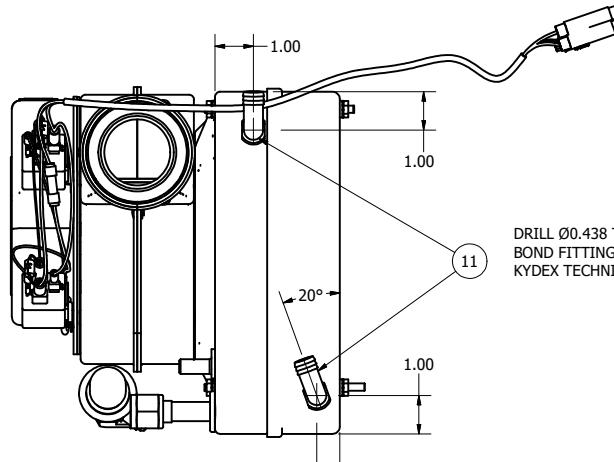
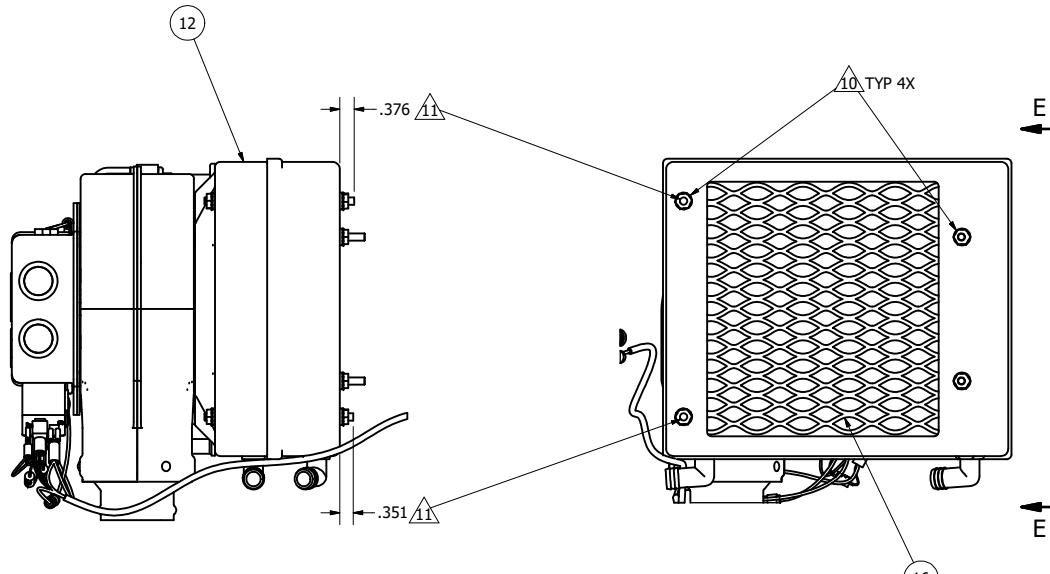
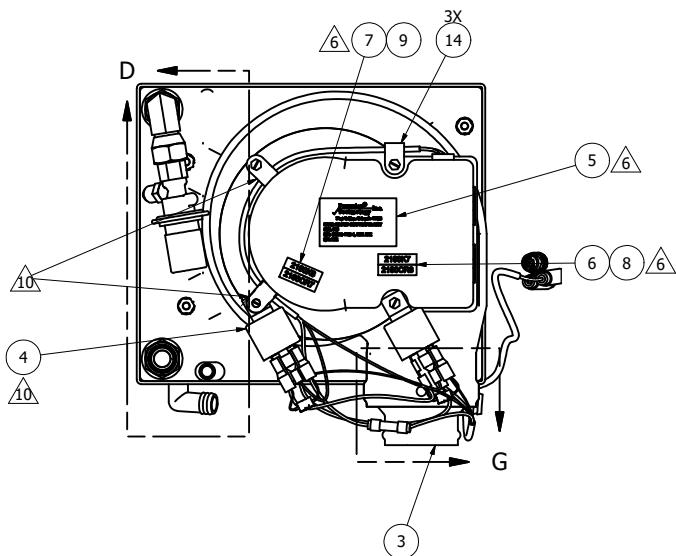
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	8 C6X-S	ELBOW MALE/FEMALE
3	1	505AC-4403-21	REDUCER
4	1	505AC-6103-2	WIRING HARNESS
5	1	505AC-6123-1	RH FWD EVAPORATOR LABEL
6	1	505AC-6123-11	2160K7 DECAL
7	1	505AC-6123-12	2160K6 DECAL
8	1	505AC-6123-13	2160CR8 DECAL
9	1	505AC-6123-14	2160CR7 DECAL
10	3	CR9163-4-05	SELF PLUGGING BLIND RIVET
11	2	ES49008-4	ELBOW
12	1	ES75204-1	EVAPORATOR (ALT: ES75202-4)
13	3	NAS1149DN432J	WASHER
14	3	NY3-C	CABLE CLAMP
15	2	SECO-7A8	SECO SEAL
16	1	ES04070-2	SCREEN 7.0 X 6.375

NOTES:

1. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPARED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
2. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25 AFTER ASSEMBLY.
3. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
4. SEAL MATING SURFACES W/ PEMATEX BLACK RTV #16B, 4. DOW CORNING RTV-732 BLACK, OR EQUIV.
5. PREPARE SURFACE BY WIPIPING WITH ISOPROPYL ALCOHOL.
6. INSTALL DECAL IN ACCORDANCE WITH BHT-ALL-SPM, CHAPTER 8, PARAGRAPH 58-24
7. TRIM DOWN EXCESS GLUE BUILDUP AS NECESSARY TO INSTALL REDUCER

8

- PREPARE PART FOR PRIMER:
 - a. USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
 - b. THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
 - c. USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.
- PAINT ADHESION TEST:
 - FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.
 - a. DRY TAPE TEST DONE ONCE EVERY LOT.
 - i. PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
 - ii. REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
 - iii. LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.
 - b. WET TAPE TEST DONE ONCE PER LOT.
 - i. SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS.
(ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
 - ii. DRY THE SURFACE WITH A CLEAN CLOTH.
 - iii. REPEAT STEPS i THRU iii OF DRY TAPE TEST.
- 0. MOUNT GLARE SHIELD, SUPPORTS, AND ELECTRICAL HARNESS USING EXISTING ASTENERS
- 1. CUT EXCESS EVAPORATOR MOUNTING THREADS

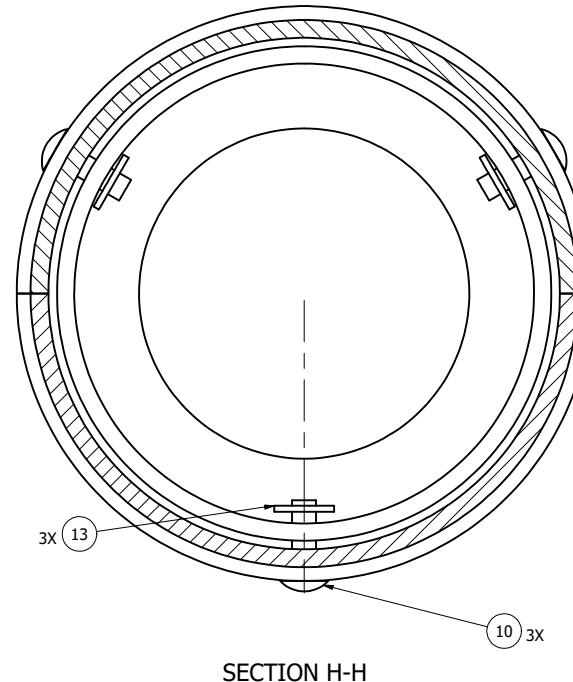
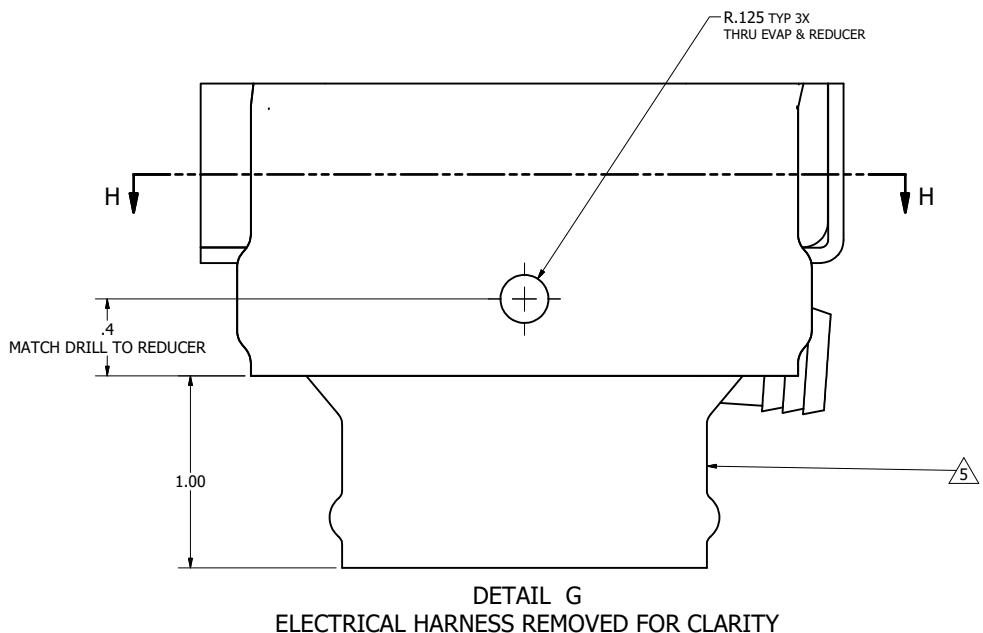


-1 RH FWD EVAPORATOR ASSEMBLY

DRILL Ø0.438 THRU OUTER CASE
BOND FITTING IN ACCORDANCE WITH
KYDEX TECHNICAL BRIEF TB-150-A, E

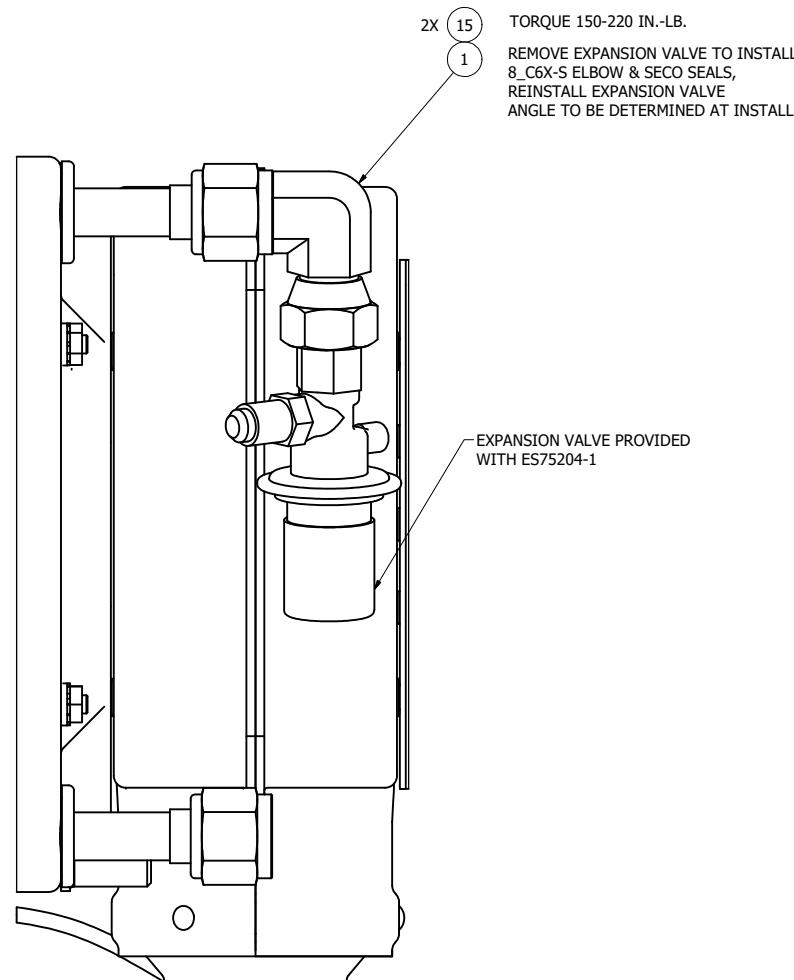
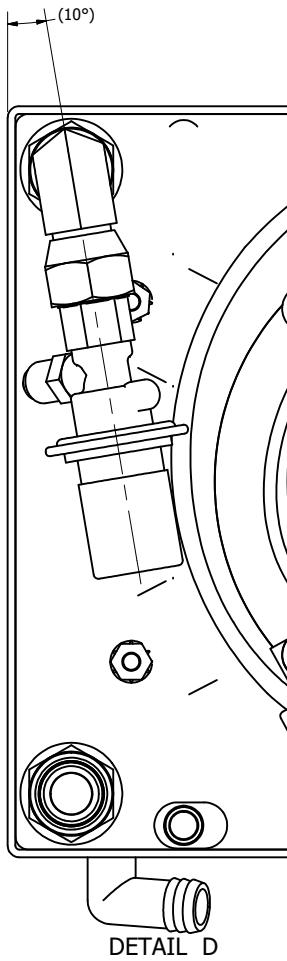
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 Paravion® Technology	TITLE		DRAWING NUMBER		
	RH FWD EVAPORATOR PARTS		505AC-4403		
DIMENSIONS IN INCHES					
TOLERANCES EXCEPT WHERE NOTED:					
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.XX = ± .05	ZA			7/30/18	ECO
.XXX=± .010					
ANGLES=± 1°					
DO NOT SCALE DRAWING					
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THREADS: INTERNAL CLASS 2B EXTERNAL CLASS 2A	3RD ANGLE PROJECTION	SHEET			2 OF 15

-1 RH FWD EVAPORATOR ASSY CONT.

Paravion® Inc. Technology		TITLE RH FWD EVAPORATOR PARTS		DRAWING NUMBER 505AC-4403	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY ZA	CHK'D BY	APPROVED BY	DATE 7/30/18
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		REV ECO E	
	3D ANGLE PROJECTION	PROTO	DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	3 OF 15	SHEET

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-1 RH FWD EVAPORATOR ASSY CONT.

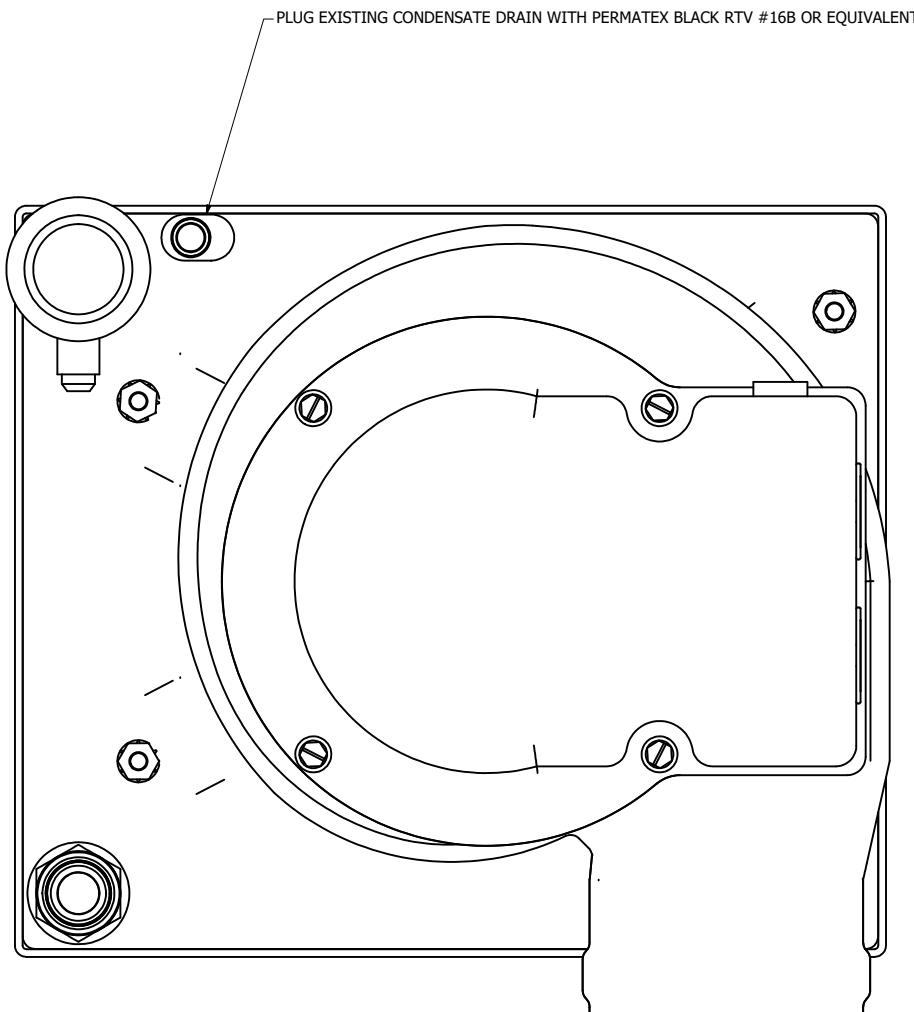
VIEW E-E
505AC-6103-21 WIRING REMOVED FOR CLARITY

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4 OF 15					

NECESSARY MODIFICATIONS IF USING ES75202-4



ES75202-4 MODIFICATION

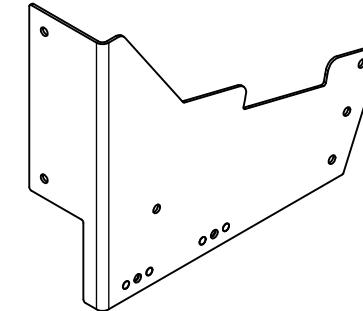
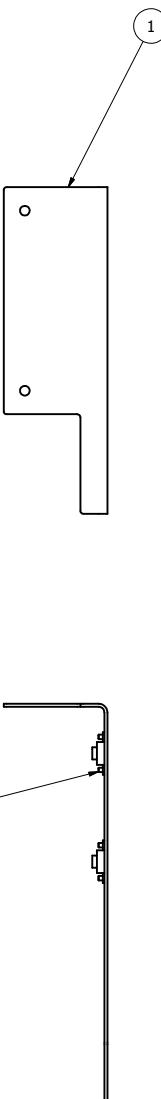
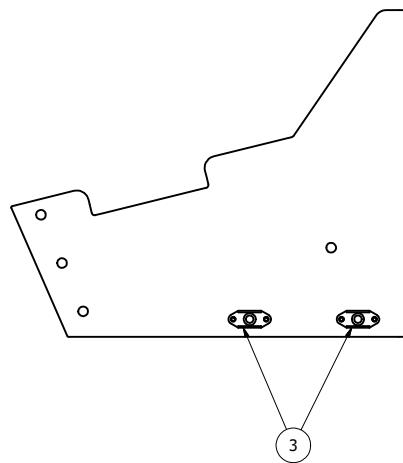
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ZA			7/30/18				E
WHERE NOTED:							
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.XXX = ± .010							
ANGLES = ± 1°							
THREADS:							
INTERNAL: CLASS 2B							
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3RD ANGLE PROJECTION		DO NOT SCALE DRAWING			SHEET		
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PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4403-11	OUTSIDE BULKHEAD SUPPORT
2	4	MS20426AD3-3	RIVET (ALT: CCR264SS3-3)
3	2	MS21059L3	NUT PLATE FLOATING

-6 BULKHEAD SUPPORT ASSEMBLY

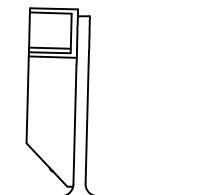
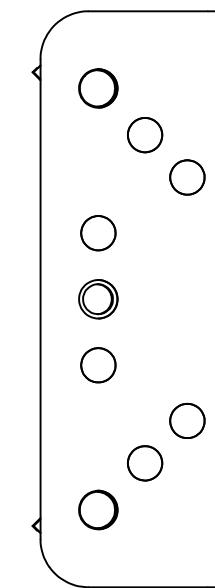
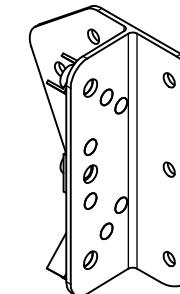
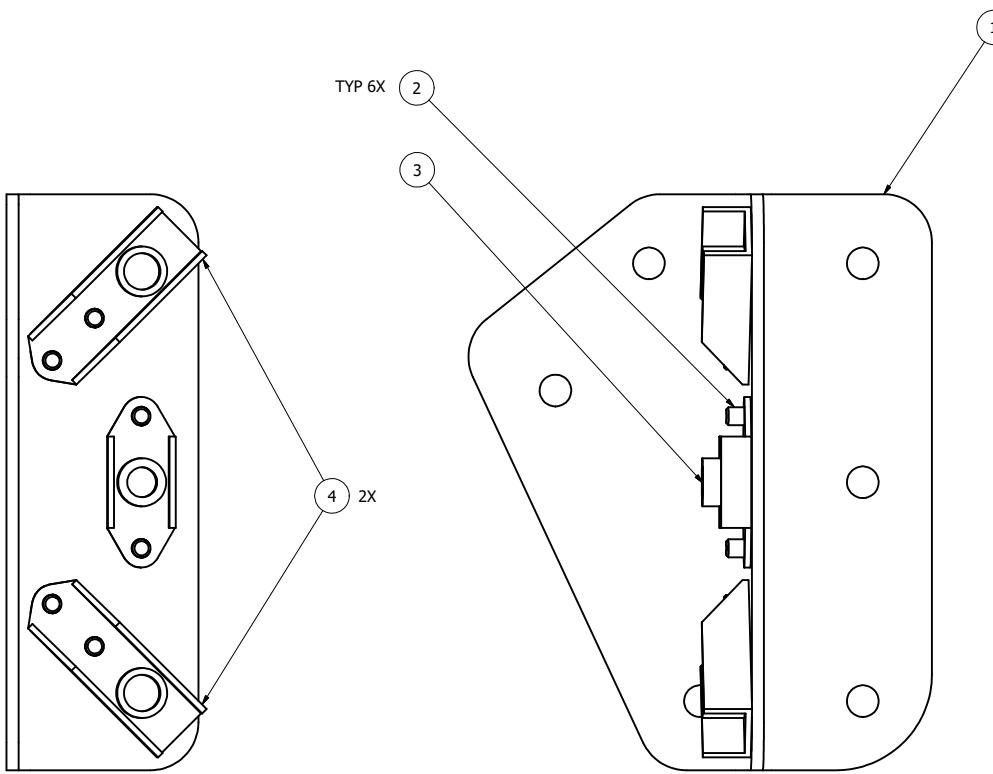
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4403-15	BULKHEAD BRACKET
2	6	MS20426AD3-3	RIVET (ALT: CCR264SS3-03)
3	1	MS21059L3	NUT PLATE FLOATING
4	2	MS21061L3	NUT PLATE ONE LEG FLOATING

-7 BULKHEAD BRACKET ASSEMBLY

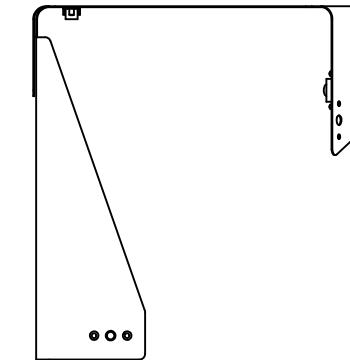
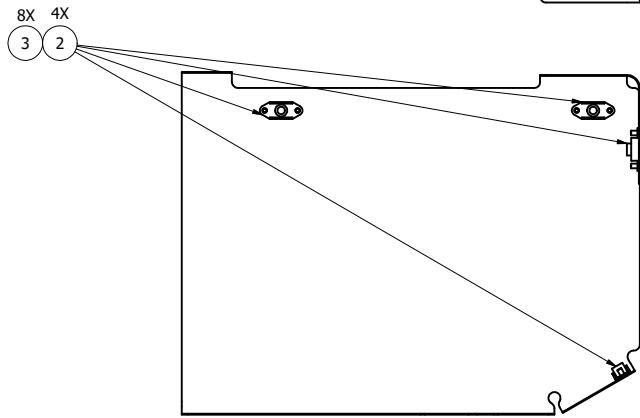
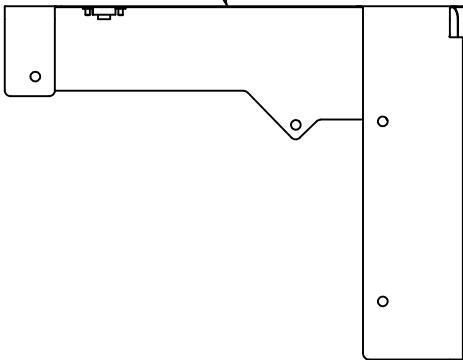
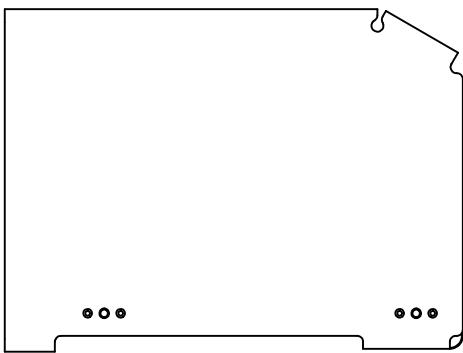
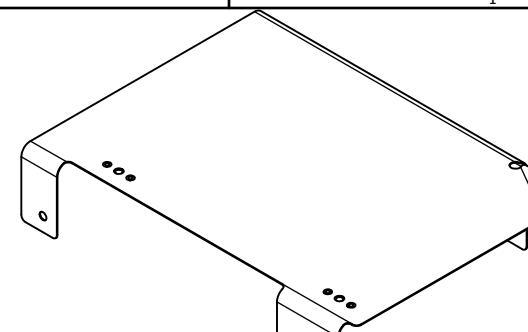


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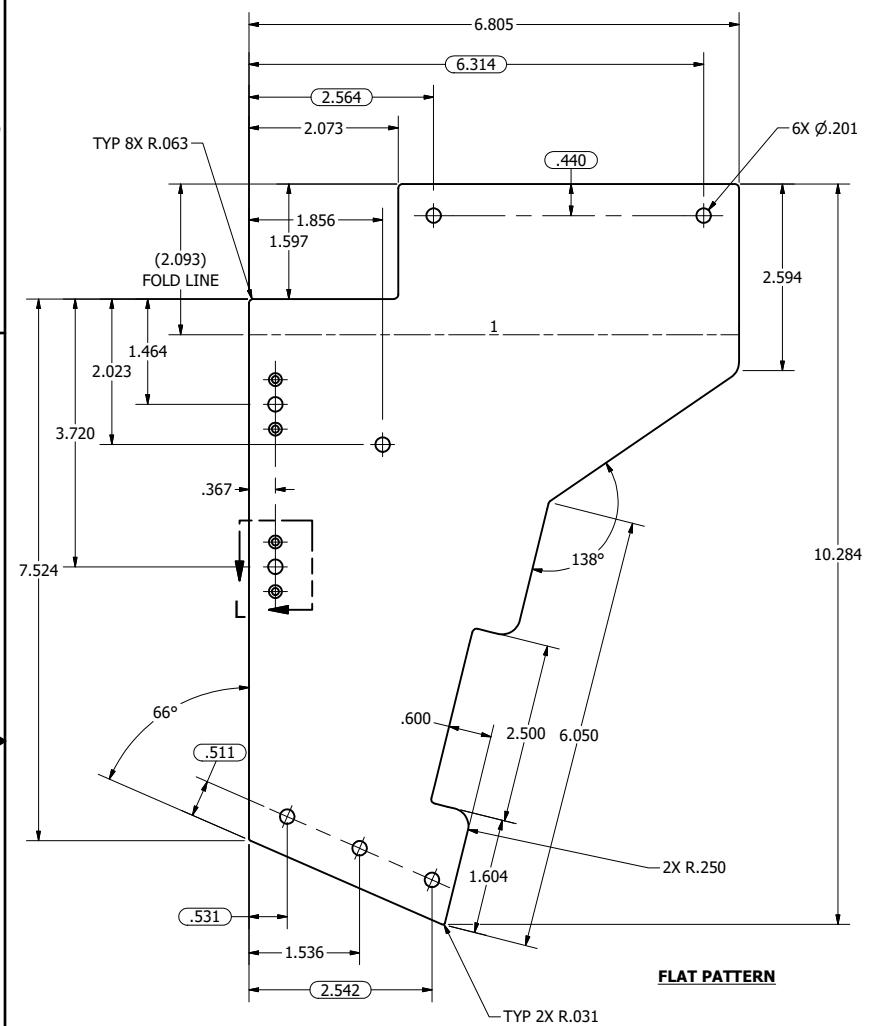
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-4403-16	EVAP SHROUD TOP
2	4	MS21059L3K	DIMPLED NUT PLATE FLOATING
3	8	MS20426AD3-3	RIVET

-8 SHROUD TOP ASSEMBLY

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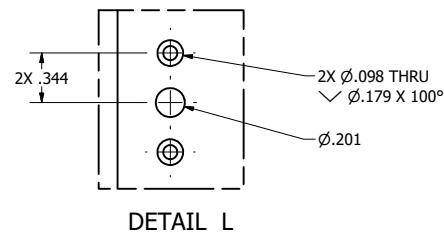
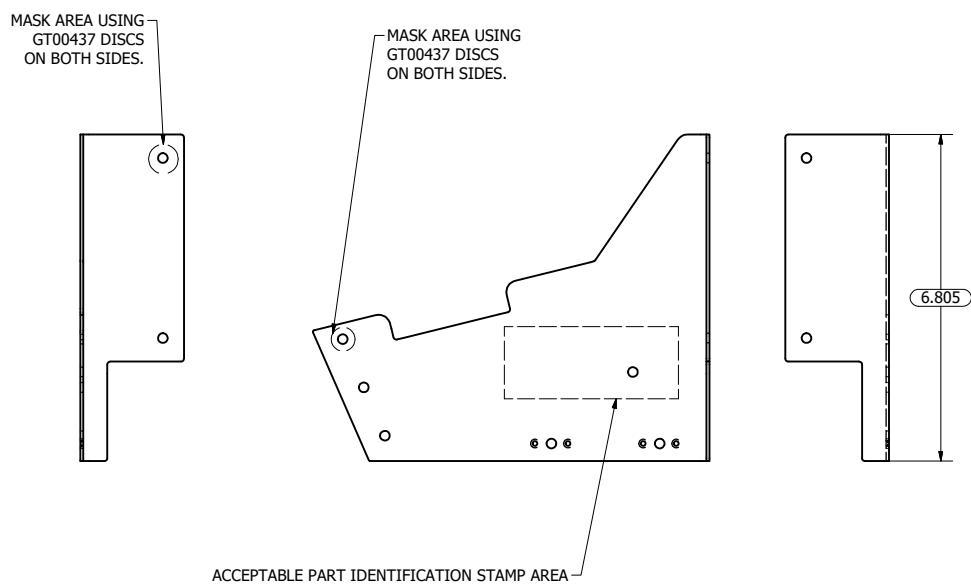
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 3D ANGLE PROJECTION		SHEET 8 OF 15			
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505AC-4403-11 OUTSIDE BULKHEAD SUPPORT ⁸

MATERIAL: 6061 T6 ALUMINUM PER QQ-A-250/11, AMS4027
 STOCK SIZE: 0.063" THICK SHEET
 FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
 PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.
 PAINT ADHESION TEST: /
 FINISH COAT FLAT BLACK PER BHTI CONSUMABLES LIST #C265.



BEND TABLE							
BEND ID	BEND DIRECTION	BEND ANGLE	BEND RADIUS	PUNCH	Die	MANUFACTURING ANGLE	MANUFACTURING DIM.
1	DOWN	90	.12	#9	#1	82°	2.093

BREAK ALL SHARP EDGES

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 Technology Inc.

✓ Technology Inc.

TITLE
 RH FWD EVAPORATOR
 PARTS

505AC-4403

DRAWN BY	CHK'D BY	APPRVD BY	DATE	REV	ECO
ZA			7/30/18		

DO NOT SCALE DRAWING
 INTERNAL: CLASS 2B
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 3RD ANGLE PROJECTION

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SHEET
 9 OF 15

505AC-4403-13 PEDESTAL BRACKET



MATERIAL: 6061 T6 ALUMINUM PER QQ-A-250/11, AMS4027

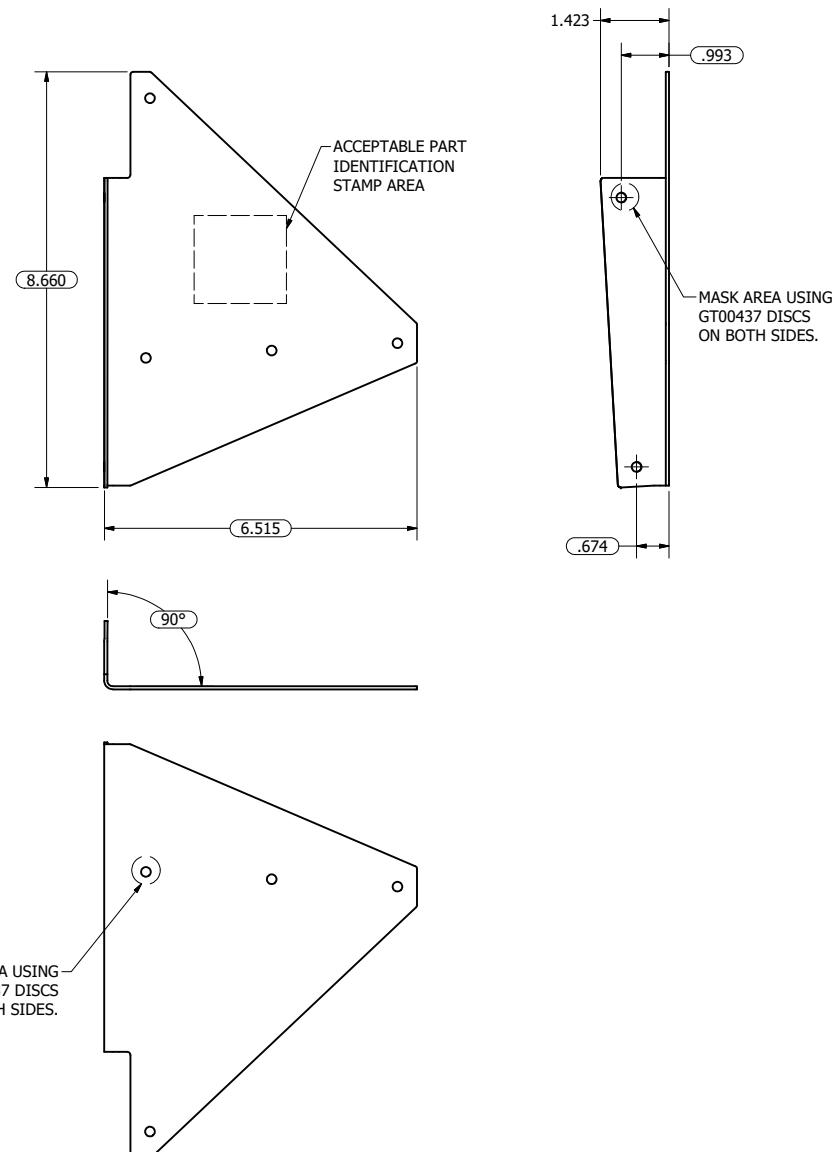
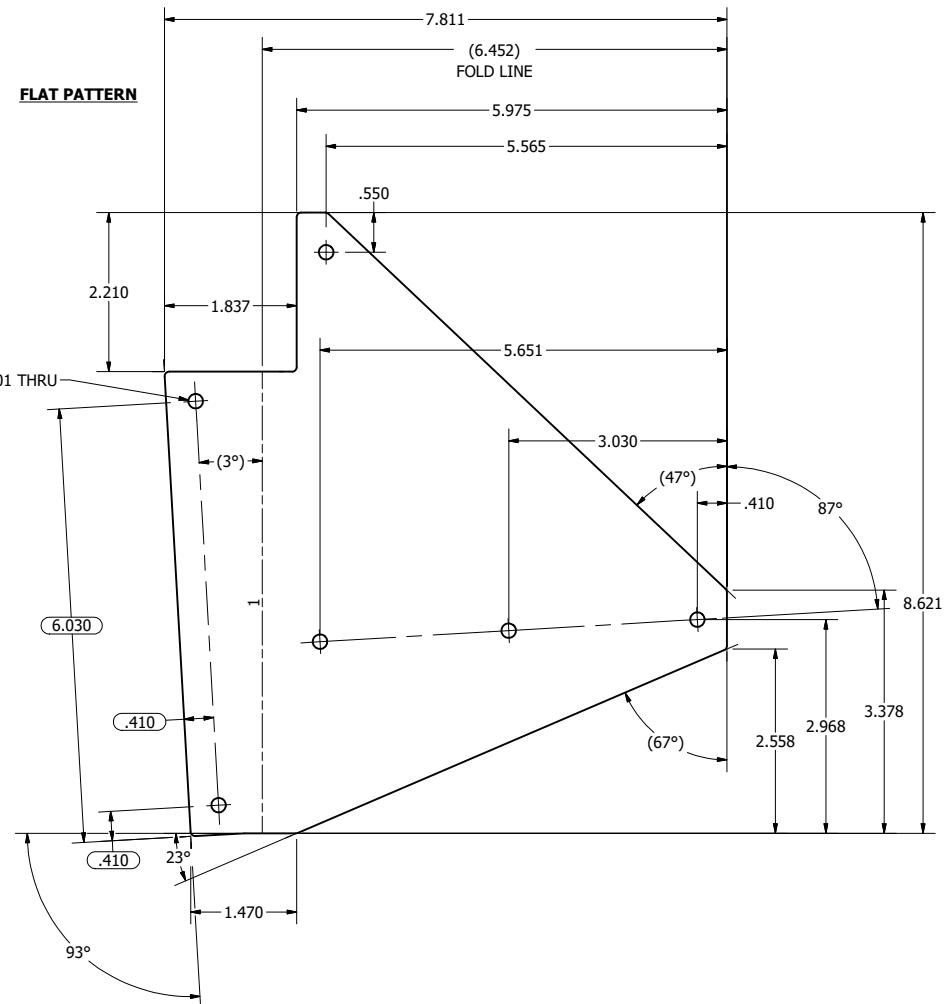
STOCK SIZE: 0.063" THICK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 9

FINISH COAT FLAT BLACK PER BHTI CONSUMABLES LIST #C265.



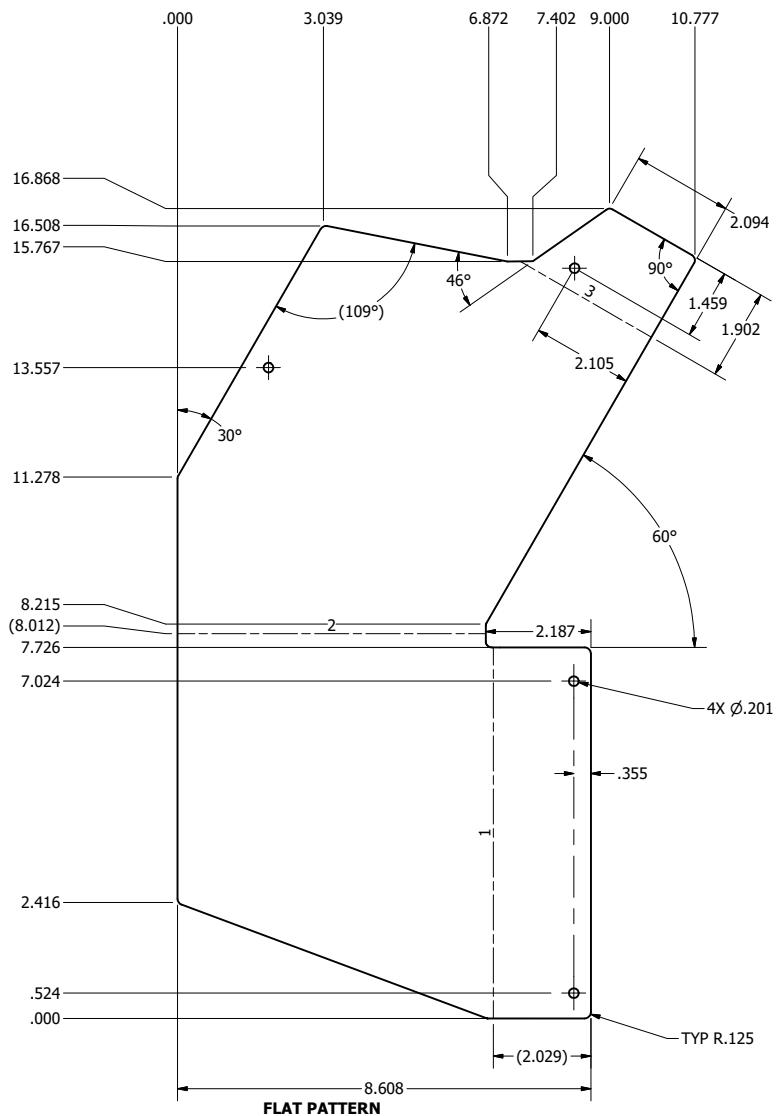
Paravion® Inc. Technology		TITLE RH FWD EVAPORATOR PARTS		DRAWING NUMBER 505AC-4403	
DRAWN BY	CHK'D BY	APPRVD. BY	DATE	REV	ECO
ZA			7/30/18		E
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION					
SHEET 11 OF 15					

BREAK ALL SHARP EDGES

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505AC-4403-14 EVAP SHROUD BOTTOM

MATERIAL: 6061 T6 ALUMINUM PER QQ-A-250/11, AMS402

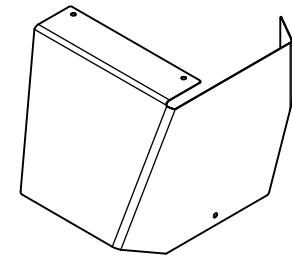
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FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2

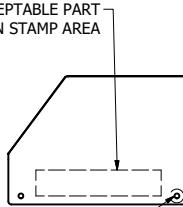
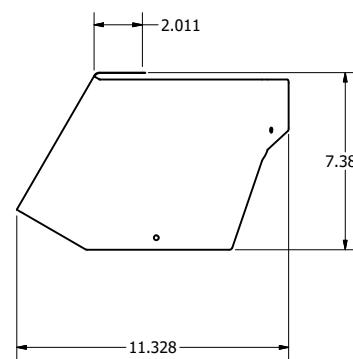
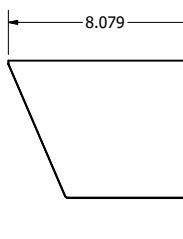
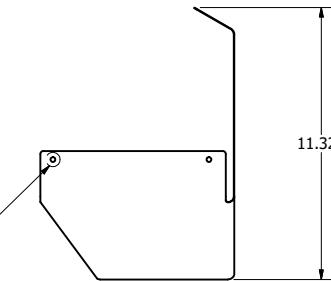
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS

PAINT ADHESION TEST: 9

FINISH COAT FLAT BLACK PER BHTI CONSUMABLES LIST #C26

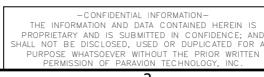


MASK AREA USING
GT00437 DISCS
ON BOTH SIDES



ACC
IDENTIFICATION

MASK AREA USING
GT00437 DISC.



BEND TABLE							
BEND ID	BEND DIRECTION	BEND ANGLE	BEND RADIUS	PUNCH	Die	MANUFACTURING ANGLE	MANUFACTURING DIM.
1	UP	60	.25	#15	#20	105°	1.940
2	UP	90	.25	#15	#20	84°	8.012
3	UP	60	.25	#15	#20	105°	1.902

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 Paravion® Technology	TITLE			DRAWING NUMBER		
	RH FWD EVAPORATOR PARTS			505AC-4403		
DIMENSIONS IN INCHES	DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO
TOLERANCES EXCEPT WHERE NOTED:	ZA			7/30/18	E	
.X = ± .1						
.XX = ± .05						
.XXX = ± .010						
ANGLES = ± 1°						
THREADS:	 3RD ANGLE PROJECTION			DO NOT SCALE DRAWING		
INTERNAL CLASS 2B				© 2021 PARAVION TECH INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		
EXTERNAL CLASS 2A				SHEET		
				12 OF 15		

505AC-4403-15 BULKHEAD BRACKET 

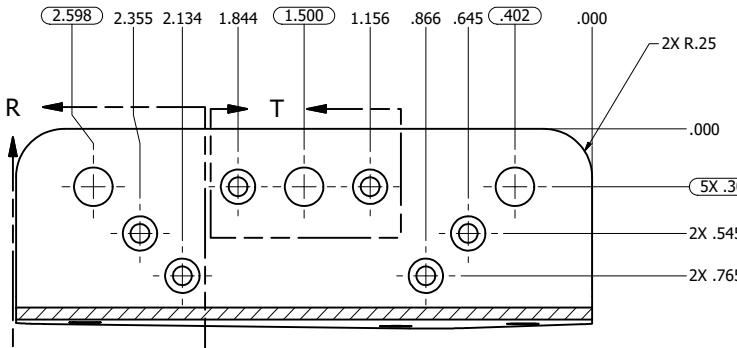
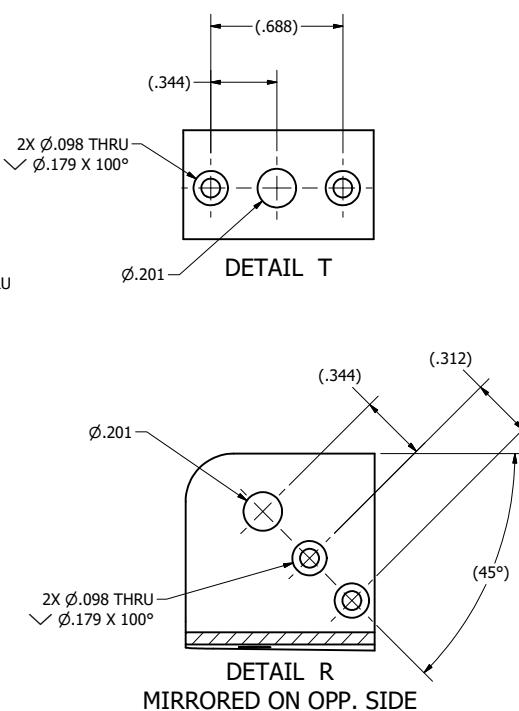
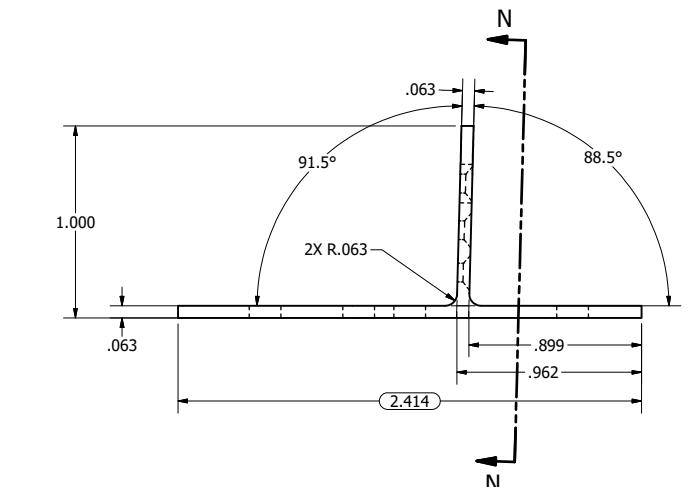
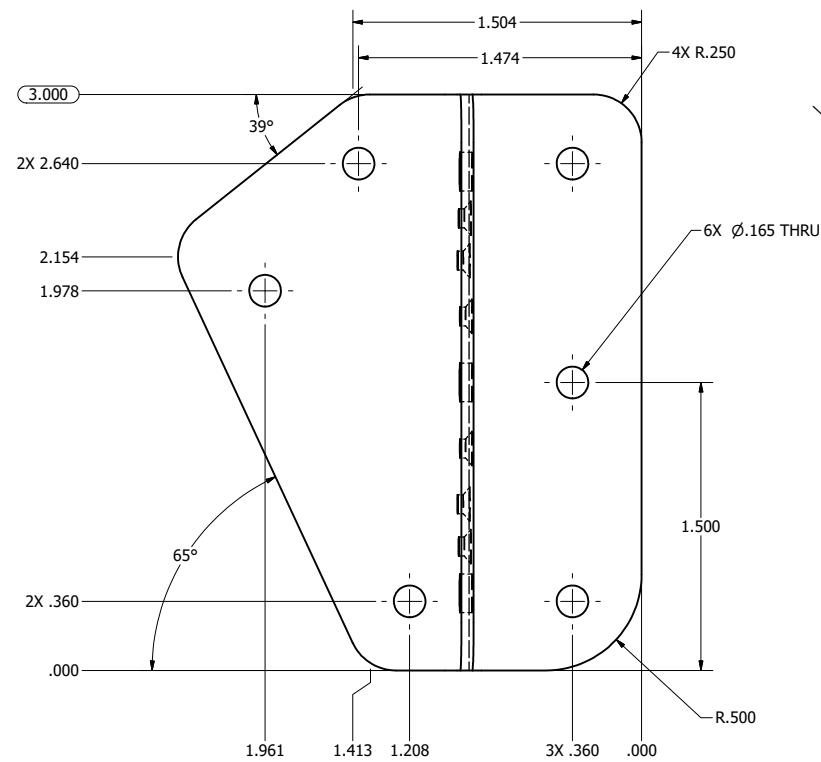
MATERIAL: 6061 T6 ALUMINUM PER QQ-A-200/8, AMS4173

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 9

FINISH COAT FLAT BLACK PER BHTI CONSUMABLES LIST #C265.



SECTION N-N

BREAK ALL SHARP EDGES

4

3

2

1

Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		RH FWD EVAPORATOR PARTS		505AC-4403	
DRAWN BY	CHK'D BY	APPRVD BY	DATE	REV	ECO
ZA			7/30/18		E
DO NOT SCALE DRAWING		3RD ANGLE PROJECTION		SHEET	
INTERNAL: CLASS 2B		INTERNAL: CLASS 2A		13 OF 15	
EXTERNAL: CLASS 2A		EXTERNAL: CLASS 2A			

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PROTO

THREADS:

INTERNAL: CLASS 2B

EXTERNAL: CLASS 2A

ANGLES: $\pm 1^\circ$ XX = $\pm .05$ XXX = $\pm .010$

REV: E

ECO: 1

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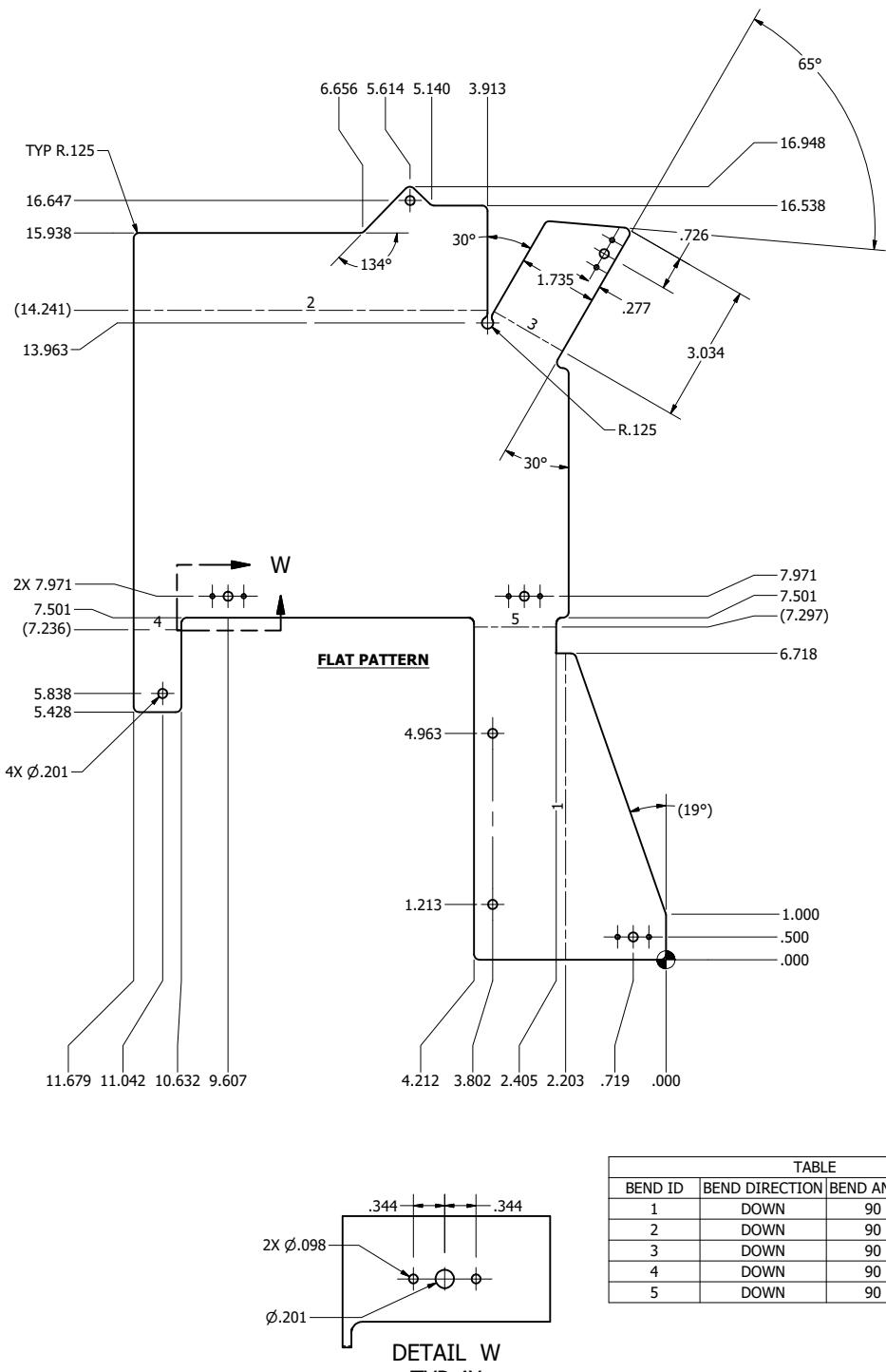
DO NOT SCALE DRAWING

3RD ANGLE

PROJECTION

SHEET

13 OF 15



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PROTO

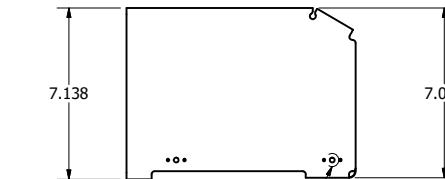
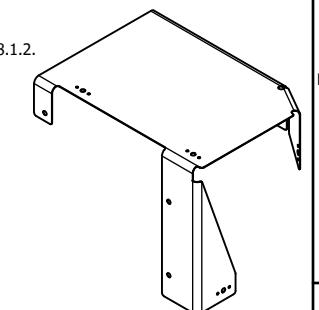
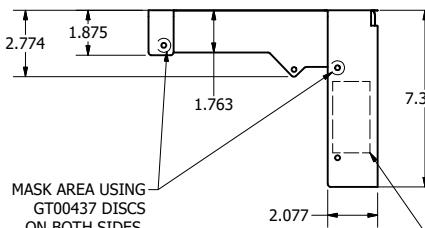
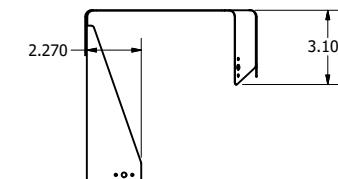
TITLE		DRAWING NUMBER	
RH FWD EVAPORATOR PARTS		505AC-4403	
DRAWN BY	CHK'D BY	APPRV'D BY	DATE
ZA			7/30/18
REV	ECO		
E			

DO NOT SCALE DRAWING

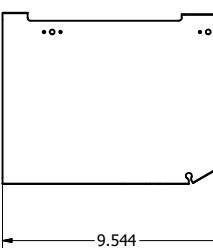
3RD ANGLE PROJECTION

INTERNAL: CLASS 2B
 EXTERNAL: CLASS 2A

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MASK AREA USING
GT00437 DISC.MASK AREA USING
GT00437 DISCS
ON BOTH SIDES.

ACCEPTABLE PART IDENTIFICATION STAMP AREA

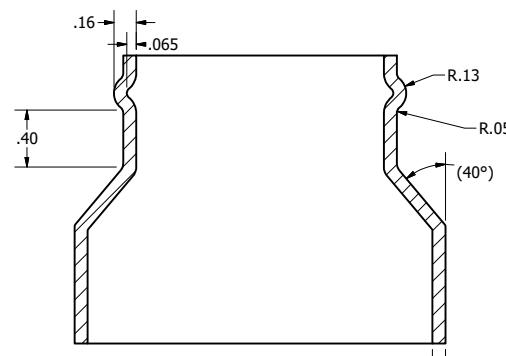
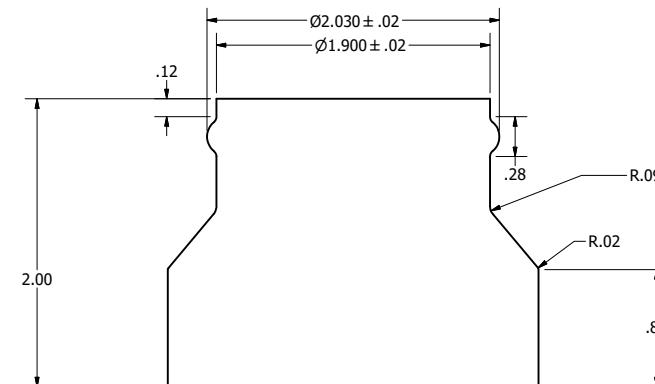
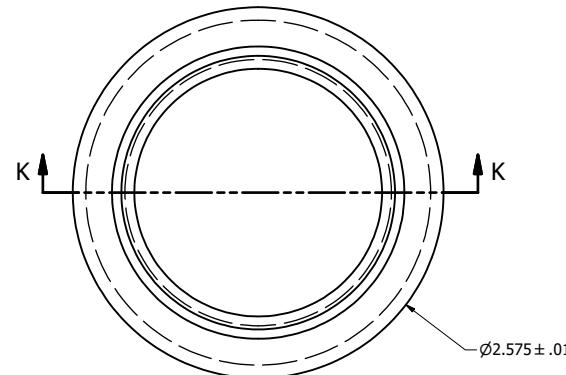


SHEET
 14 OF 15

-21 REDUCER

MATERIAL: KYDEX 100 P-1 TEXTURE, COLOR: BLACK 52000

NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-4403-21 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN $\Delta 0.030"$. THE DRAWING IS THE DESIGN MASTER. ANY FEATURE DEFINED ON THE DRAWING SUPERCEDES ALL MODEL DEFINITION.



SECTION K-K

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Paravion®
Technology Inc.

TITLE
RH FWD EVAPORATOR
PARTS

DRAWING NUMBER
505AC-4403

DRAWN BY	CHK'D BY	APPVD BY	DATE	REV	ECO
ZA			7/30/18		E
DO NOT SCALE DRAWING					SHEET
 3RD ANGLE PROJECTION					15 OF 15